

Date: Thursday, 02/10/2008 8:24:07 AM
 User: Julie Lecocq

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services			Drawing Name	: WEARPLATE		
Job Number	42382			Part Number	: D3719041		
Estimate Number	13107			Drawing Number	: D3719 REVA		
P.O. Number				Project Number	: N/A		
This Issue	02/10/2008	S.O. No.	:	Drawing Revision	: A		
Prsht Rev.	NC			Material	:		
First Issue	/ /	Type	SMALL /MED FAB	Due Date	: 10/10/2008 Qty: 24 Um: Each		
Previous Run	42041						
Written By							
Checked & Approved By	<u>JUL 08. 10.02</u>						
Comment	: Est Rev:A New Issue 07-12-19 EC verified by DD Est Rev:B 08-09-25 add QC5 DD verified by:EC						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304S16GA	304/316 Sheet .063
Comment: Qty.: 0.5933 sf(s)/Unit Total : 14.2380 sf(s) 304/316 .060 Sheet Batch: <u>108724</u> <u>B 8-10-2</u>		
2.0	WATER JET	FLOW WATER JET
Comment: FLOW WATER JET 1-Cut as per Dwg D3719 Dwg Rev: <u>A</u> <u>B 8-10-2</u> Prog Rev: <u>A</u>		
2-Deburr if necessary <u>B 8-10-2</u>		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
<u>B 8-10-2</u>		
Comment: INSPECT PARTS AS THEY COME OFF MACHINE		
4.0	QC8	SECOND CHECK
<u>S 08/10/02</u> <u>427</u> <i>warter</i>		
Comment: SECOND CHECK		
5.0	D30093	Cup
Comment: Qty.: 4.0000 Each(s)/Unit Total : 96.0000 Each(s) CUP Batch: <u>B41176</u> <u>E 8-10-6</u> <u>X108</u>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 02/10/2008 8:24:07 AM
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Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld D3009-3 cups as per dwg D3719 M107051

✓27

2-Weld hard facing as per Dwg D3719

A/R 2059B Hard Coat rod Batch: M109213

2 8-10-8

7.0 QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

8.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8 08 10 68 ✓27

9.0 POWDER COATING

POWDER COATING



M 106442

27X

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME: 1:50

01

08/10/08

OVEN TEMPERATURE: 323

0F

FINISH TIME: 2:20

M 106442

10.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-10-08 (22)

11.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST498

SL 08/10/08 82

12.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/10/09 27

Job Completion



U 08-10-09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

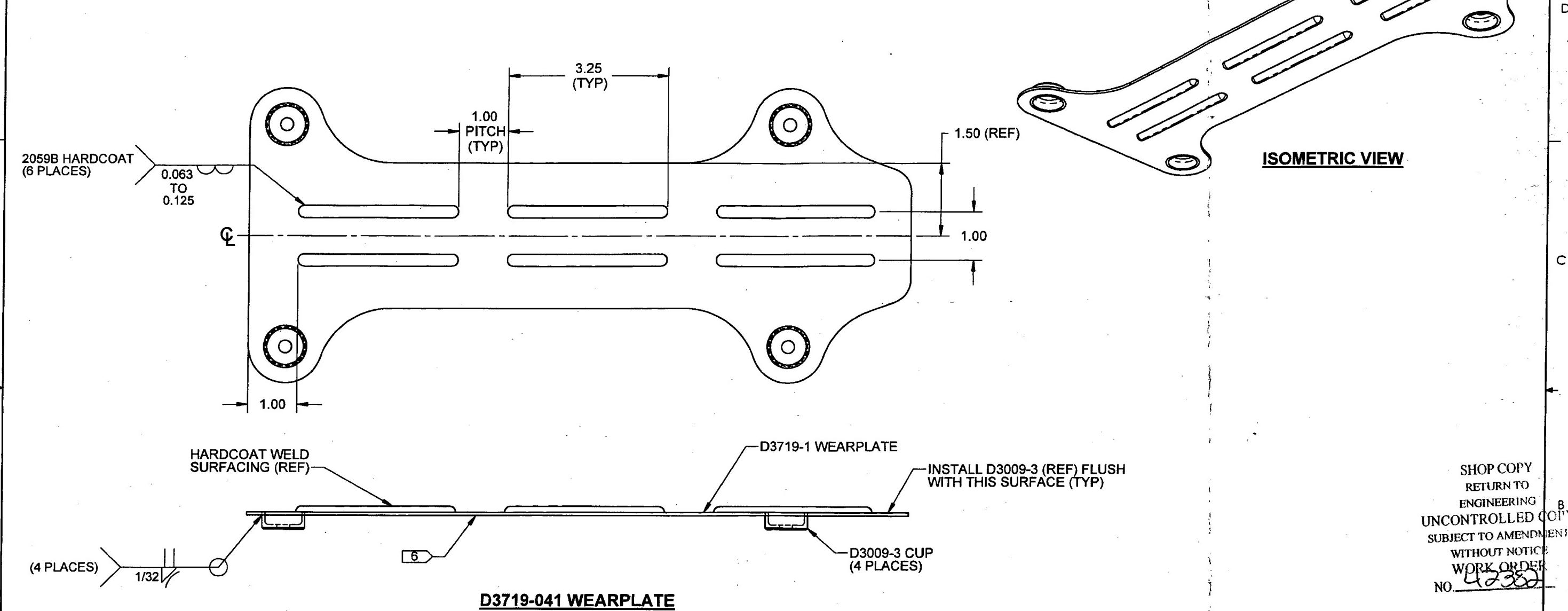
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

PARTS LIST FOR D3719-041 WEARPLATE:		
QTY.	PART NUMBER	DESCRIPTION
1	D3719-1	WEARPLATE
4	D3009-3	CUP



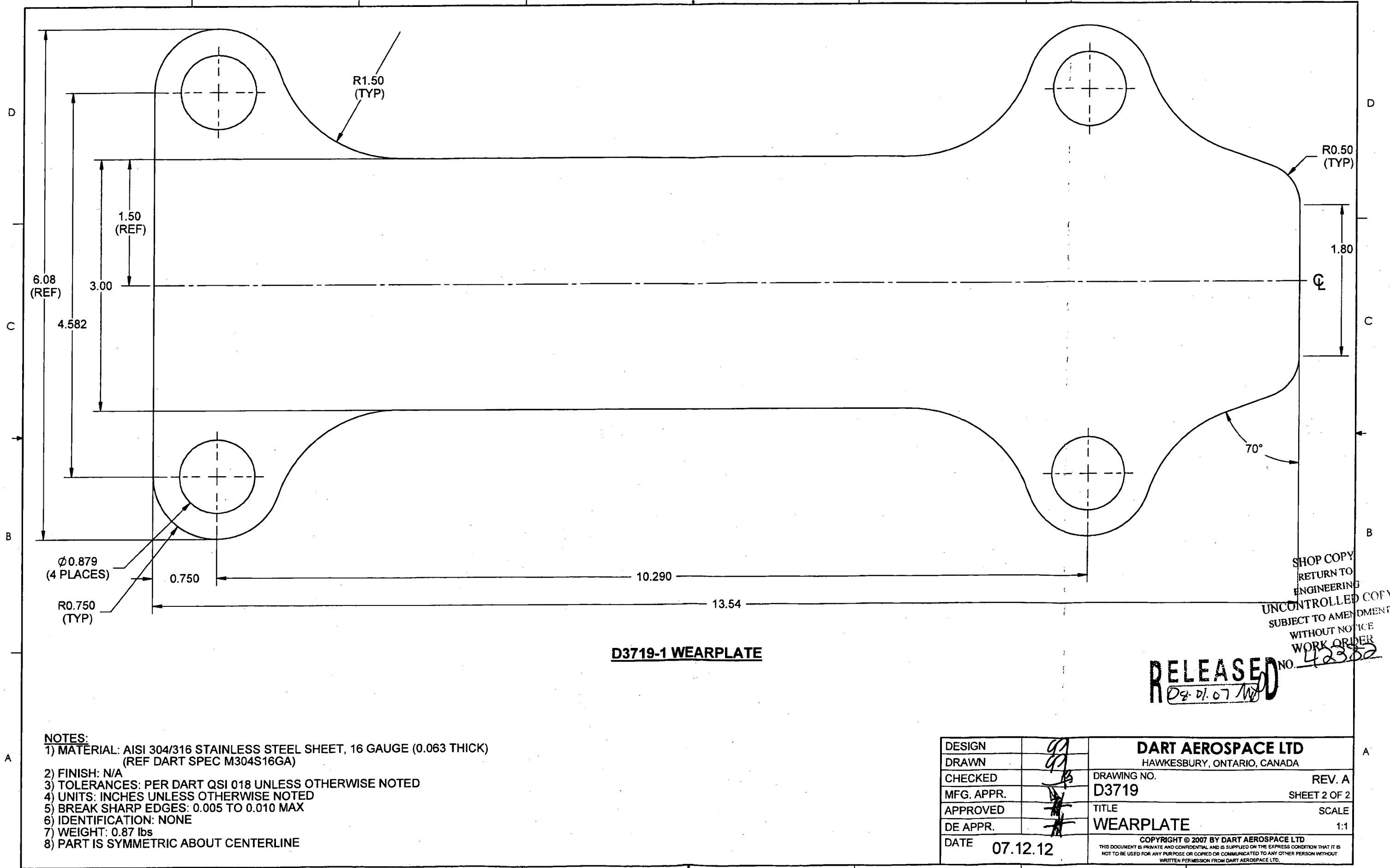
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 42382

RELEASED
08-01-07 JMK

- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: POWDER COAT "GREY SANTEX" (4.3.5.6) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3719-041" & B/N USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 1.11 lbs
 - 8) PART IS SYMMETRIC ABOUT CENTERLINE
 - 9) WELD PER DART QSI 004

A	NEW ISSUE	CP	07.12.12
REV.	DESCRIPTION	BY	DATE
DESIGN	901	DART AEROSPACE LTD	
DRAWN	901	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AB	DRAWING NO.	
MFG. APPR.	AB	REV. A	
APPROVED	AB	D3719	SHEET 1 OF 2
DE APPR.	AB	TITLE	SCALE
DATE	07.12.12	WEARPLATE	1:12

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DART AEROSPACE LTD

Work Order: 42382

Description: WEAR PLATE

Part Number: 3119-~~004~~-1

Inspection Dwg: D3714-1, Rev: A

Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

x First Article x Prototype

Measured by: **IP**

Audited by: S. S. /

Prototype Approval:

Date: 8-10-2

Date: 08/10/02

Date: 1/2

Rev	Date	Change	Revised by	Approved
A		New Issue	P/D D3719-041 KJ/JLM	